

Monday, 1/7/2008 3:42:06 PM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOOR ASSEMBLY
 Job Number : 36652A
 Estimate Number : 11454
 P.O. Number : Part Number : D41269401
 This Issue : 1/7/2008 S.O. No. : Drawing Number : D412-694
 Prsht Rev. : NC Project Number : N/A
 First Issue : / / Type : SMALL /MED FAB Drawing Revision : C1
 Previous Run : 27340A Material :
 Due Date : 2/28/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 08.01.8
 Comment : Est Rev: A 05.12.09, New Issue KJ/RF
 Est Rev: B 06.04.18 New dwg rev. ecn781 EC
 Est Rev: C 06.07.11 Revised per B24660 KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: * Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Issue red decal labels for D412-694-01 CHG005

2.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-01 Drill Process

1- Drill (7) holes using Ø(#40) drill. Drill (3) holes top/bottom Ø(#40) for insert (do not pass thru) using B30-23000-01 as per Dwg D412-694 page 4 (view P). ✓

2- Open (1) hole to 11/16" (0.688) for the handle using unibit. Transfer (4) Ø(#30) holes from D3151-041 to the door and c'sink from far side for the rivet. Transfer (2) holes Ø(3/16") for MS24694-C5 screw as per Dwg D412-694 page 4 (view P). ✓

Note: D3151-041 orientation in the door.

3- Open (3) holes Ø(#19) or (0.166) top/bottom of the door and c'sink Ø0.300 x 100° from the far side and D3155-041/-042 bracket assembly as per Dwg D412-694 page 4 (view P). ✓

4- Drill Ø(#30) holes using drill Jig D3144-T1 for the doublers. Drill (2) holes in two places Ø 3/16" (0.188) for the slot opening. Router slot using D3144-T2/-T3 as per Dwg D412-694 page 2. ✓

Note: The (12) holes for the (6) nut plates can not be less than 0.290" from inside edge.

5- Open (3) holes to Ø37/64" (0.578) at top/bottom insert for D3163-041 cover assembly as per Dwg D412-694 page 4 (view P). Drill Ø(#30) outer door handle as shown in view Z-Z page 2. Open holes to Ø0.257. ✓

6- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-1. Use unibit to open holes to Ø 37/64" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view K, L, M, Q). ✓

W/O:		WORK ORDER CHANGES					
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QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section-C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number:



Seq. #:

Machine Or Operation:

Description :

- ✓ 7- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-2. Use unibit to open holes to Ø 3/764" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view H, J).
- ✓ 8- Drill (27) pilot holes Ø(#30) using drill Jig DT8703-3LH for D3126 brackets as per Dwg D412-694 page 2 (view G-G). Use unibit to open holes Ø3/764" (0.578) for inserts.
- ✓ 9- Drill (2) Pilot holes Ø(#30) by transfer from D3152-041 bracket. Use unibit to open holes to Ø3/764" (0.578) for inserts as per Dwg D412-694 page 6 (view Q).
- 10- Drill (12) Ø(#30) holes from the edge of the door to opposite side for D3162-041 bracket using a long drill and keep drill perpendicular. Ensure (4) holes used from the center of the hole to top and bottom edge of the thick section of D3163-041 cover assembly. Compare hole depth with rivet in the foam as per Dwg D412-694 page 4 (view P) and (view R-R/S-S). Drill (8) Ø(#30) holes from the edge of the door using a long drill and keep drill perpendicular. About the (4) last holes around the small square of the cover, take the measurement 0.250" from each corner of the D3163-041 cover.

3.0

8000528

Insert



Comment: Qty.: 55.0000 Each(s)/Unit Total : 55.0000 Each(s)
Insert
Batch M 15893 (XSS)
A/R Hysol EA934NA M 107007
Expiry Date: 31 Jan 2009

m/08/02/04

4.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

- 1-Install inserts as per Dwg D412-694 page 2 (view G-G); page 6 (view H, J, L, M, Q).
2- Sand flush excess Hysol around the insert on both doors.

m/08/02/07

PID

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect that inserts are flush with the surface.

See 02-07

6.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1. Apply Primer filler and reducer around the inserts on both doors.

A/R 11045 Primer Filler
A/R 12375S Reducer

Batch: 106 803
Batch: 106 803

RT 08 02-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 08/02/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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08/02/07	4	Find Small crack at Bottom of where inserts and Seal D3116-9	<i>[Signature]</i> Paxur	fill up with Hysol EA 934 NA and milled filler M 107007 m 100 859 EX 31 Jan 2009 let cure 24 hours	<i>[Signature]</i> 08/02/07	<i>[Signature]</i> 08/02/07	<i>[Signature]</i> Paxur	<i>[Signature]</i> 08/02/07

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7.0

QC5

INSPECT WORK TO CURRENT STEP



Inspected



Comment: INSPECT WORK TO CURRENT STEP

8.0

D31105

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle

Batch

B27081

ml

9.0

D31151

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch

B36152

ml

10.0

D31167

Seal ZX2054



Comment: Qty.: 5.6666 f(s)/Unit Total : 5.6666 f(s)

Seal ZX2054

Batch

m 27239

ml

11.0

D31169

Seal ZX1267



Comment: Qty.: 6.4166 f(s)/Unit Total : 6.4166 f(s)

Seal ZX1267

Batch

B17463

ml

12.0

D3121041

Bracket Assembly



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bracket Assembly

Batch

B24338x1
B36727x2

ml

13.0

D3121043

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

~~B21167~~ *B21379*

ml

ml 08/02/07

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Job Number:



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Machine Or Operation:

Description :

14.0

D31221

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lever

Batch

B25539

ml

15.0

D31231

Cam



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cam

Batch

M 10536-17

ml

16.0

D31241

Hook



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hook

Batch

M10536-17

ml

17.0

D31242

Hook



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hook

Batch

M10536-17

ml

18.0

D31261

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch

B36728

ml 08/02/19

19.0

D31263

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch

B24680

ml

20.0

D31265

Bracket



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket

Batch

B18658 x1

(x2) *ml* 08/02/19
B36729 (x4)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D3132041

Rod Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod Weldment

Batch M10536-17

ml

22.0

D3133042

Rod Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod Weldment

Batch M10536-17

ml

23.0

D3135041

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch B36730 ✓

ml

24.0

D3137045

BRACKET ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET ASSEMBLY

Batch B27339

ml

25.0

D31381

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover

Batch B25178 ✓

ml

26.0

D31391

Guard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Guard

Batch B18863

ml

27.0

D31393

Guard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Guard

Batch B24751

ml

D3139 *rev 2008/2/15*

W/O:		WORK ORDER CHANGES					
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Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D314005

Door Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Door Kit

Batch

B36652A

M106688 min 2008/2/15

ml

29.0

D31411

Spring #204-032-734-001



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spring #204-032-734-001

Batch

B34725

ml

30.0

D31443

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

B18816

ml

31.0

D314413

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

B21911

ml

32.0

D3144109

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

B23145

ml

33.0

D3144111

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

B21910

ml

34.0

D31481

Clevis



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clevis

Batch

M10536-17

ml 08/02/08

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QA: N/C Closed: _____ Date: _____

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Drawing Name: DOOR ASSEMBLY

Job Number: 36652A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D3151041

Doubler Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Doubler Assembly
Batch B24685

ml

36.0

D3152041

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket Assembly
Batch B18867

ml

37.0

D3155041

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket Assembly
Batch B27178

ml

38.0

D3155042

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket Assembly
Batch B26933

ml

39.0

D31561

Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bracket
Batch B24772

ml

40.0

D3162041

Bracket Assembly



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Bracket Assembly
Batch B24688 (x8)

B 36733 (x2)

ml

41.0

D3162043

BRACKET ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket Assembly
Batch B24451

ml

ml 08/02/07

W/O:		WORK ORDER CHANGES					
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Job Number: 36652A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

D3162044

BRACKET ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket Assembly
Batch B36734

ml

43.0

D3163041

Cover Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Cover Assembly

B27349

ml

44.0

D3183041

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket Assembly
Batch B37193

ml

45.0

D32031

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Handle
Batch B30158A

ml

46.0

D33081

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Doubler
Batch B21912

ml

47.0

AN52510R6

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Screw
Batch M15943

ml

48.0

AN52510R7

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Screw
Batch M106166

ml

ml 08/02/07

W/O:		WORK ORDER CHANGES					
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Job Number: 36652A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

49.0

AN960JD8

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch

M106112

ml

50.0

AN960JD10L

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch

104374

ml

51.0

AN960JD10LL

Washer



Comment: Qty.: 15.0000 Each(s)/Unit Total : 15.0000 Each(s)

Washer

Batch

M19600

ml

52.0

AN960JD416L

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch

M106303

ml

53.0

BSP45

Commercial Rivet



Comment: Qty.: 79.0000 Each(s)/Unit Total : 79.0000 Each(s)

Commercial Rivet

Batch

11821

ml

54.0

BSP46

Commercial rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Commercial rivet

Batch

M101237

ml

55.0

M7885243

CR-3213-4-03

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rivet

Batch

14477

ml 08/01/17

W/O:		WORK ORDER CHANGES					
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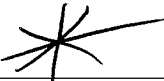
Machine Or Operation:

Description :

56.0

M7885344

Rivets



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Rivets

Batch

M75659

19099

ml

57.0

MS203922C9

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

M11784

ml

58.0

MS203922C17

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

M18949

ml

59.0

MS203923C21

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

M104156

ml

60.0

MS20426AD33

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rivet

Batch

M1563

ml

61.0

MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

Batch

M3459

ml

62.0

CR3212404

Cherry Rivet



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Rivet

Batch

N/A

See step 56.0

ml 08/01/17

W/O:		WORK ORDER CHANGES					
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Machine Or Operation:

Description :

63.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch

M105054

ml

64.0

MS21042L08

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch

M105925

ml

65.0

MS21072L3

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nutplate

Batch

M18728 (x1)

M107003 (x3)

ml

66.0

MS24665151

Cotter Pin



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Cotter Pin

Batch

M14526

ml

67.0

MS24693S271

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

M14478

ml

68.0

MS24694C5

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

11755 x1

M106815 x3

ml

69.0

MS24694S5

Screw



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Screw

Batch

M18949

ml 08/02/07

W/O:		WORK ORDER CHANGES					
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Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

70.0

MS24694S50

Screw



V

Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Screw

Batch

M104625

ml

71.0

MS24694S98

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

103684

ml

72.0

MS27039105

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch

M3501

ml

73.0

MS27039106

Screw



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Screw

Batch

M 11754 (x 4)

M106815 x 10

ml

74.0

MS27039108

Screw



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Screw

Batch

M105076

ml

75.0

MS35275233

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch

11822

ml

76.0

MS35649264

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

11822

ml 08/01/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 3:42:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 36652A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

77.0

MS356503252

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

11735

ml

78.0

MS518597

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch

M 106421

ml

79.0

NAS43DD310

Spacer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Spacer

Batch

M 19099

ml

80.0

NAS43DD314

Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Spacer

Batch

M 19347

ml 08/01/17

81.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-01 Assembly Process

1- Install D3162-041 as per Dwg D412-694 page 4 (view R-R/S-S) and D3156-1 bracket as per (view T-T/U-U). Open holes to #30 (0.128) for rivet and alodine the open holes.

Note: Start installation window side. Wait to fix D3162-041/-043.

2- Install D3151-041 Doubler as per Dwg D412-694 page 4 (view P).

3- Connect D3132-041 Rod Weldment with D3122-1 Lever and D3133-041 Rod Weldment as per Dwg D412-694 page 4 (view P).

4- Assemble D3123-1 Cam with D3124-1/-2 Hook with D3155-041/-042 Bracket Assembly as per Dwg D412-694 page 4 (view P).

5- Install D3203-1 handle with D3308-1 doubler as per Dwg D412-694 page 2 (view Z-Z).

6- Install D3155-041/-042 Bracket Assembly and D3110-5 Handle as per Dwg D412-694 page 4 (view P) and page 2. Adjust rod weldment until everything works properly and looks in place.

ml 08/02/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 3:42:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 36652A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

82.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Door 21

83.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-01 Assembly Process (Continued)

1- Install D3116-7-0680 Seal and doublers. Transfer slot opening in the seal as per Dwg D412-694 page 2 (view V-V and N).

Note: If this is the D412-694-013, wait until the VIP trim is fixed on the door.

2- Install D3110-5 Handle Assembly in the D3163-041 Cover Assembly. Ensure Handle works freely. Ensure D3163-041 cover assembly is aligned with the door edge on both sides and D3110-5 Handle works properly.

3- Transfer the holes to the cover with the hole finder. EXCEPTION: the (4) holes around the handle. Install the bracket with the holes from the small square of the cover (Ø0.250")

4- Open 15/64" (0.234) holes to D3163-041 cover assembly and D3135-041 handle weldment. Transfer D3139-1/-3 guard holes in cover assembly and drill holes for nutplate. Deburr and touch up holes with alodine as per Dwg D412-694 page 2.

5- Install MS21072-L3 Nutplate and Guard as per Dwg D412-694 page 2.

6- Transfer (#30) holes from D3144-13 doubler to seal and door. Ensure D3116-9-0770 is properly aligned as per Dwg D412-694 page 2 (section NN-NN). Apply 732 RTV Clear (A/R) in the hole prior to installing rivet and then in the rivet head after installation.

A/R RTV732 Clear Batch: M 105700 Expiry Date: 23 July 2009

7- Install D3126 Brackets and D3138-1 Cover as per Dwg D412-694 page 2 (view G-G and NN-NN).

8- Install and assemble brackets as per Dwg D412-694 page 2 and 5 (view H, J, L, M and Q).

m/08/02/21

84.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Install door on mock up helicopter to insure proper fit and function

Door 21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AP Date: 20/02/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 3:42:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 36652A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

85.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1- Finish installing D3163-041 in the door.

2- Install red decal before closing cover.

ml 08/02/21

ml 08/02/21

86.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2008-220

87.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

08/02/26

(1)

88.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/26

Job Completion



mi 2008/2/26

(1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
05.12.01

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
X				D412-894-01	DOOR ASSEMBLY
	X			D412-894-02	DOOR ASSEMBLY
		X		D412-894-03	DOOR ASSEMBLY
			X	D412-894-04	DOOR ASSEMBLY
		1	1	D3110-1	ESCUTCHEON
		1	1	D3110-3	HANDLE
1	1			D3110-5	HANDLE ASSEMBLY
		1	1	D3111-041	PLATE ASSEMBLY
		2	2	D3112-1	GUIDE
		1	1	D3113-1	SPRING
		1	1	D3114-1	PIVOT
1	1			D3115-1	BRACKET
		1	1	D3116-11-0180	SEAL
		1	1	D3116-5-0680	SEAL
1	1			D3116-7-0680	SEAL
1	1			D3116-9-0770	SEAL
		1		D3119-041	COVER ASSEMBLY
		1		D3119-042	COVER ASSEMBLY
		1		D3120-1	COVER
		1		D3120-2	COVER
		1		D3120-3	COVER
		1		D3120-4	COVER
3	3			D3121-041	BRACKET ASSEMBLY (ROLLER)
1	1			D3121-043	BRACKET ASSEMBLY (ROLLER)
		1		D3121-044	BRACKET ASSEMBLY (ROLLER)
1	1			D3122-1	LEVER
2	2			D3123-1	CAM
1	1			D3124-1	HOCK
1	1			D3124-2	HOCK
		1	1	D3125-1	LEVER
		1	1	D3125-3	LEVER
		1	1	D3125-5	LEVER
		1	1	D3125-7	LEVER
1	1			D3126-1	BRACKET (SLIDER)
1	1			D3126-3	BRACKET (SLIDER)
5	5			D3126-5	BRACKET (SLIDER)
1	1			D3127-1	SPACER
		1	1	D3128-1	SHIM
		2	2	D3129-1	LEVER
		2	2	D3130-1	CLEVIS BASE
		1	1	D3131-1	STOP
1				D3132-041	RCD WELDMENT
	1			D3132-042	RCD WELDMENT
	1			D3133-041	RCD WELDMENT
1				D3133-042	RCD WELDMENT
		1	1	D3134-1	RCD
		1	1	D3134-3	RCD
1	1			D3135-041	HANDLE WELDMENT
1	1			D3137-045	BRACKET ASSEMBLY
1				D3138-1	COVER
	1			D3138-2	COVER
1	1			D3139-1	GUARD
1	1			D3139-3	GUARD
1	1			D3139-4	GUARD
1				D3140-05	DOOR
	1			D3140-06	DOOR
		1		D3140-07	DOOR
2	2			D3140-08	DOOR
		1	1	D3141-1	SPRING
		1	1	D3143-1	CLEVIS
		3	3	D3143-3	CLEVIS
		1		D3144-1	DOUBLER
1				D3144-3	DOUBLER
	1			D3144-105	DOUBLER
	1			D3144-107	DOUBLER
1				D3144-109	DOUBLER

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
1	1			D3144-111	DOUBLER
	1			D3144-115	DOUBLER
		1		D3144-117	DOUBLER
		1		D3144-121	DOUBLER
		1		D3144-119	DOUBLER
1	1			D3144-123	DOUBLER
1	1			D3144-13	DOUBLER
		1		D3145-1	HINGE BRACKET
		1	1	D3145-2	HINGE BRACKET
		1	1	D3145-3	HINGE BRACKET
		2	2	D3145-2	HINGE BRACKET
		2	2	D3147-1	PIN
2	2			D3148-1	CLEVIS
		2	2	D3148-1	STRIKER PLATE
		2	2	D3150-1	GUIDE
1	1			D3151-041	DOUBLER ASSEMBLY
1				D3152-041	BRACKET ASSEMBLY
	1			D3152-042	BRACKET ASSEMBLY
		1	1	D3154-1	KEY
1	1			D3155-041	BRACKET ASSEMBLY
1	1			D3155-042	BRACKET ASSEMBLY
2	2			D3156-1	BRACKET
		2	2	D3157-1	SPACER
		3	3	D3159-041	BRACKET ASSEMBLY
		1		D3159-043	BRACKET ASSEMBLY
		1		D3159-044	BRACKET ASSEMBLY
10	10			D3162-041	BRACKET ASSEMBLY
1		1		D3162-043	BRACKET ASSEMBLY
1		1		D3162-044	BRACKET ASSEMBLY
1				D3163-041	COVER ASSEMBLY
1				D3163-042	COVER ASSEMBLY
1				D3183-041	BRACKET ASSEMBLY (ROLLER)
1				D3183-042	BRACKET ASSEMBLY (ROLLER)
1	1			D3203-1	HANDLE ASSEMBLY
2	2			D3308-1	DOUBLER
55	55	21	21	80-005-248	INSERT (OR SL2052-3-4)
10	10			AN625-10F6	SCREW
8	8	4	4	AN625-10F7	SCREW
		8	8	AN680D10	WASHER
18	18	4	4	AN680D10L	WASHER
13	13	32	32	AN680D10LL	WASHER
6	6			AN680D116L	WASHER
		4	4	AN680D1L	WASHER
6	6			AN680D1B	WASHER
		2	2	AN680D1L	WASHER
		2	2	AN680D1LL	WASHER
		10	10	ASL4632-80	INSERT
87	87	50	50	BSP45	RIVET
		12	12	FVM10-032	WASHER
		6	6	FVM4-032	WASHER
12	12			M7885/24	RIVET (OR CR32134-3)
		3	3	M7885/34	RIVET (OR CR32124-3)
		7	7	MS20392-1C11	PIN
		7	7	MS20392-2C15	PIN
2	2			MS20392-2C17	PIN
2	2	2	2	MS20392-3C9	PIN
2	2			MS20392-3C21	PIN
8	8			MS20426A05	RIVET
12	12			M7885/3-4	Rivet
8	8			MS20426AB4	Rivet

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
20	20			MS20426AB4	RIVET
		6	6	MS21042L05	NUT
6	6	2	2	MS21042L05	NUT
		5	5	MS21042L3	NUT
4	4			MS21042L4	NUT
4	4			MS21072-L3	NUT/PLATE
6	6	9	9	MS24665-151	COTTER PIN
4	4			MS24665-S271	SCREW
		2	2	MS24669-04	SCREW
4	4			MS24669-05	SCREW
6	6			MS24669-S5	SCREW
18	18			MS24669-S50	SCREW
		4	4	MS24669-S56	SCREW
		2	2	MS24669-S53	SCREW
		4	4	MS24669-S80	SCREW
4	4			MS24669-S98	SCREW
2	2	2	2	MS25261-R6	CLAMP
2	2	2	2	MS27039-1-05	SCREW
14	14	12	12	MS27039-1-05	SCREW
13	13	6	6	MS27039-1-08	SCREW
		2	2	MS35005-231	SCREW
2	2			MS35275-233	SCREW
2	2			MS36649-254	NUT
		4	4	MS36650-305T	NUT
2	2			MS36650-3252	NUT
2	2	3	3	MS51859-7	WASHER
		4	4	NAS1169-10L	WASHER
		14	14	NAS388-6-SP	SCREW
		15	15	NAS38188P	WASHER
7	7			NAS4000-10	SPACER
6	6			NAS4000-14	SPACER
		2	2	NAS4000-40	SPACER

GENERAL NOTES

- FOR ADJUSTMENT OF LOCKING MECHANISM PRIOR TO DOOR ASSEMBLY, SET AT UNLATCH POSITION AND ADJUST SCREW INWARD UNTIL D3124-1/2 HOOK RESTS AGAINST CUTOFF SHOWN IN VIEW A.
- IF REQUIRED, NOTCH D3125-1 LEVER (REF) TO CLEAR THE D3130-1 CLEVIS BASE (REF. 2 PLACES) TO ALLOW FOR FULL TRAVEL OF THE LEVER.
- HOLES AND PARTS TO BE LOCATED PER DRILLING JIGS, B30-23000-01; D3144-TV-T2-T3; D18703-3; D3162-041T1 (FOR -01 DOOR ASSY); B30-23000-02; D3144-T7-T8-T9; D18703-9; D3162-041T2 (FOR -02 DOOR ASSY); D3144-T4-T5-T6; D3119-041T1; D3112-TV-T2 (FOR -03 DOOR ASSY); D3144-T10-T11-T12; D3119-042T1; D3112-TV-T2 (FOR -04 DOOR ASSY).
- INSTALL INSERTS PER PART Q3 005. LOCATE TO MATCH HOLE PATTERN OF MATING PARTS.
- TOLERANCES ARE PER PART Q3 018 UNLESS OTHERWISE NOTED.
- ALL DIMENSIONS ARE IN INCHES.
- IDENTIFY D412-894-01/-02/-03/-04 DOOR ASSEMBLIES USING D2729-1 DECALS.

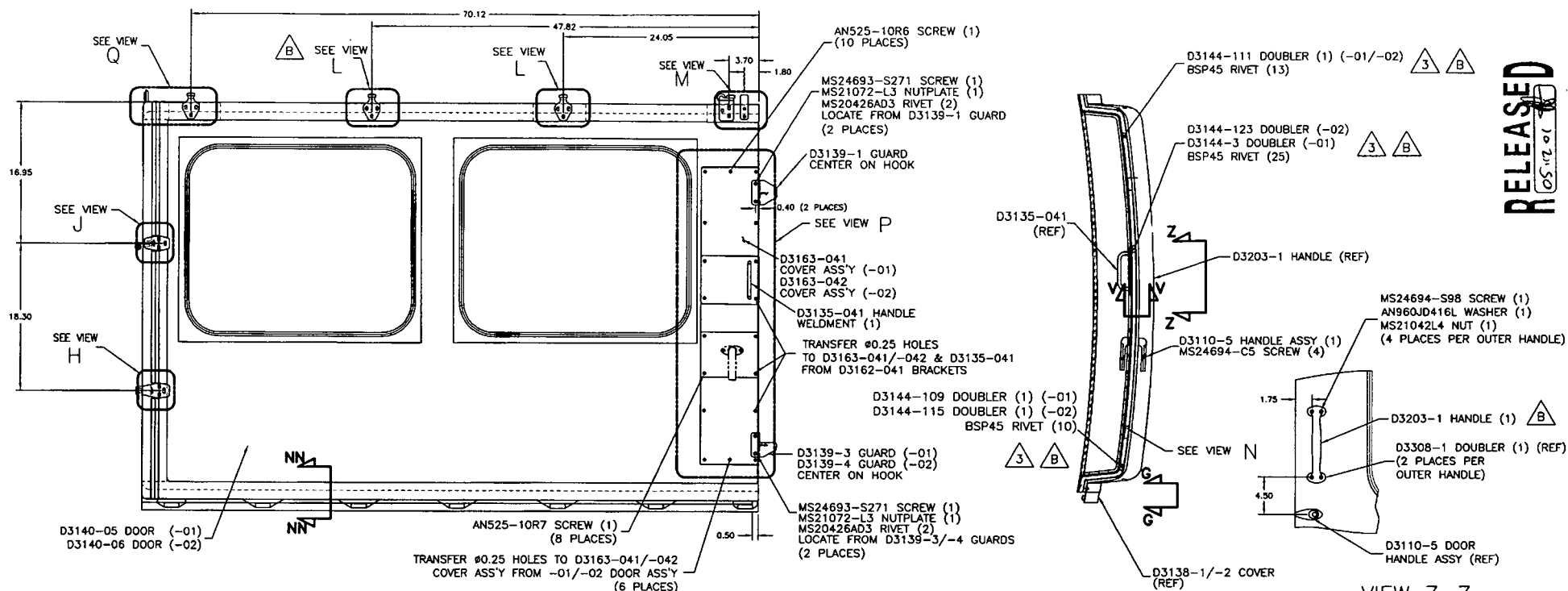
C1	06.03.28	ADD OPTION M7885/3-4
C	05.11.23	ADD D3137-045, D3162-043/-044; REMOVE D3137-041; UPDATED NOTES
B	04.10.07	UPDATE DRAWING
A	02.05.21	NEW ISSUE
DESIGN	CP	DRAWN BY RF
CHECKED	#	APPROVED
DATE	05.11.23	DRAWING NO. D412-694
		TITLE DOOR ASSEMBLY
		REV. C SHEET 1 OF 6 SCALE NTS

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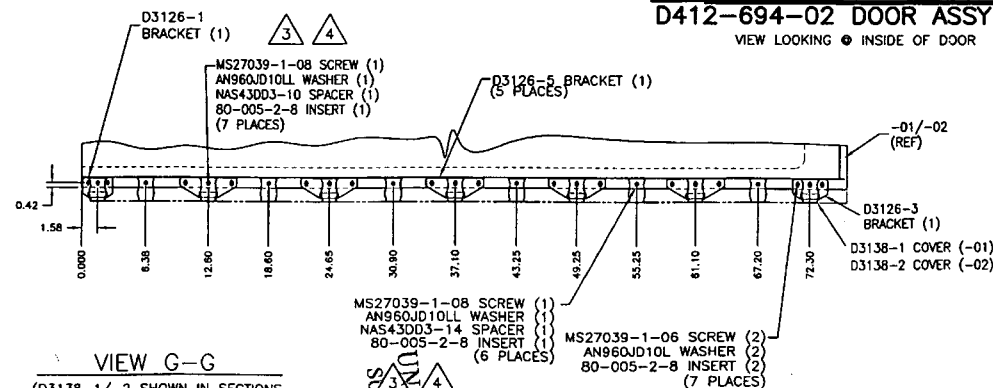
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

RELEASED
05.12.01



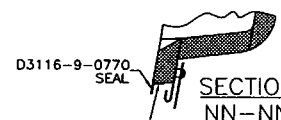
D412-694-01 DOOR ASSY (SHOWN)
D412-694-02 DOOR ASSY (OPP.)

VIEW LOOKING • INSIDE OF DOOR



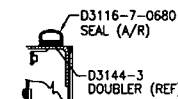
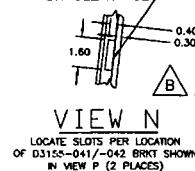
VIEW G-G

(D3138-1/-2 SHOWN IN SECTIONS
FOR CLARITY OF HDWR LOCATIONS)



D3116-9-0770
SEAL
D3144-13 DOUBLER (1)
BSP45 RIVETS (39 PLACES)
TRANSFER DRILL #30 FROM
DOUBLER TO DOOR
APPLY 732 RTV CLEAR (A/R) IN
RIVET HOLE PRIOR TO INSTALLATION
AND RIVET HEAD AFTER INSTALLATION

CUTOUT SEAL
AS REQ'D
FOR CLEARANCE



VIEW Z-Z
**OUTER DOOR HANDLE
INSTALLATION**

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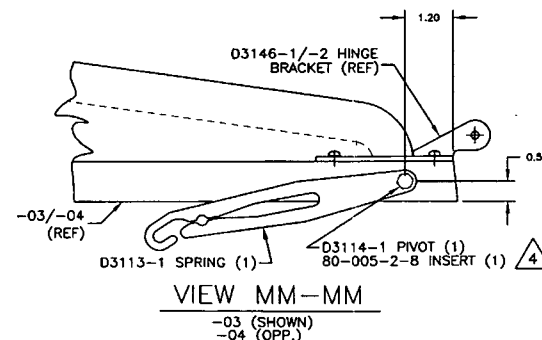
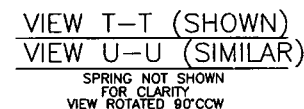
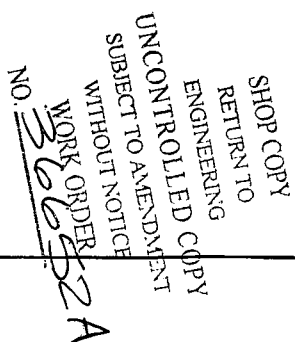
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


DESIGN CP	DRAWN BY RF	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D412-694	REV. C
DATE 05.11.23		TITLE DOOR ASSEMBLY	SHEET 2 OF 6
			SCALE NTS

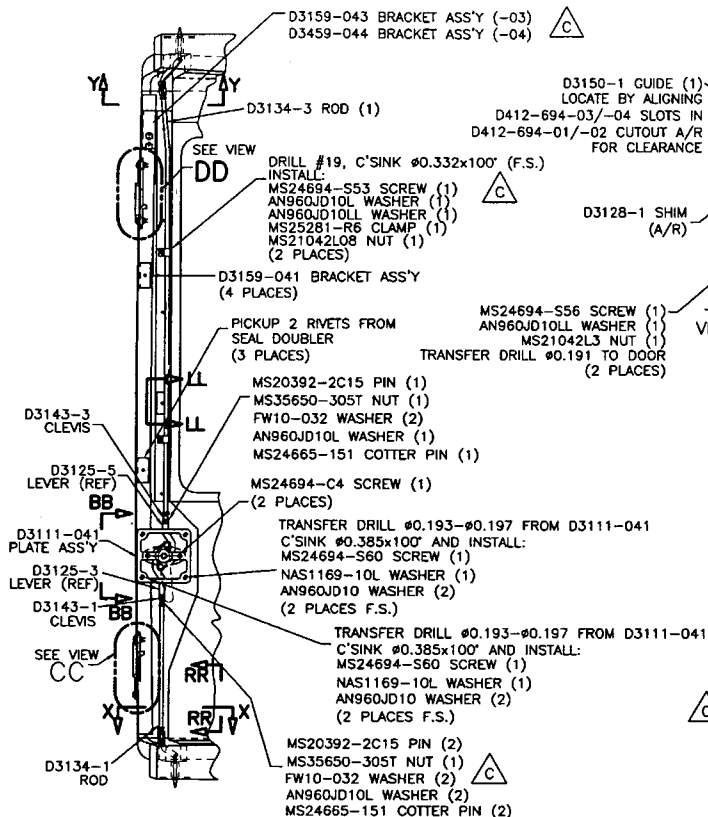
WORK ORDER
366524
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

[illegible]

102150



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	CP	RF		
	CHECKED 	APPROVED 	DRAWING NO.	REV. C
			D412-694	SHEET 4 OF 6
	DATE		TITLE	SCALE
	05.11.23		DOOR ASSEMBLY	NTS

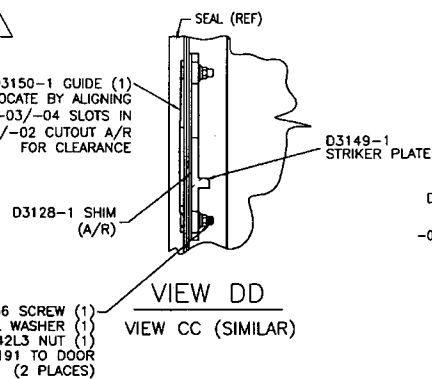


VIEW W

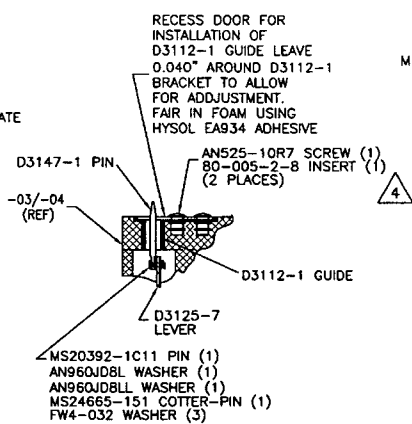
D3119-041/-042 COVER ASS'Y NOT SHOWN FOR CLARITY
SEAL ALSO NOT SHOWN FOR CLARITY

SECTION LL-LL

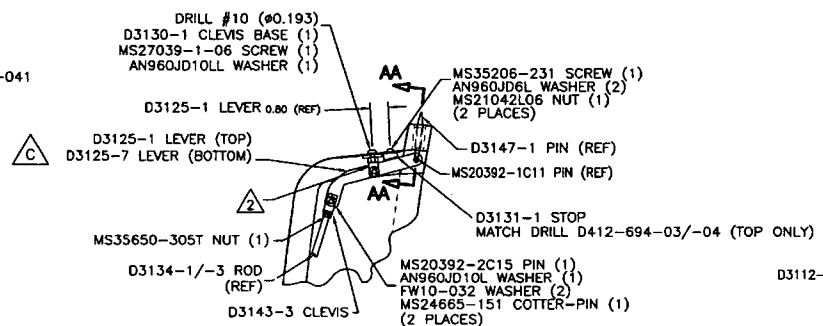
(3 PLACES)
VIEW ROTATED 90°CCW



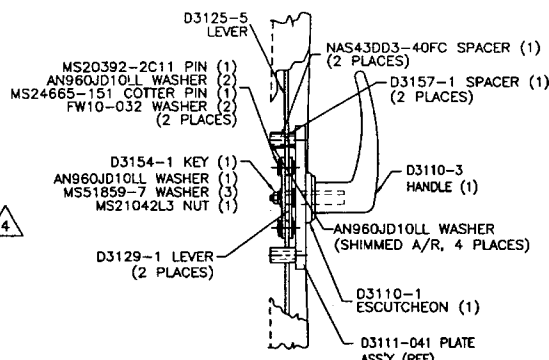
VIEW DD VIEW CC (SIMILAR)



SECTION AA-AA

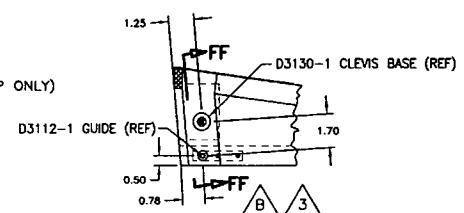


SECTION FF-FF



SECTION BB-BB

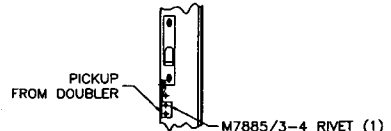
VIEW SHOWN WITH MECHANISM IN THE UNLOCKED POSITION FOR CLARITY



SECTION X-X (SHOWN)

SECTION Y-Y (SIMILAR)

D3125-1 LEVER NOT SHOWN FOR CLARITY



VIEW RR-RR

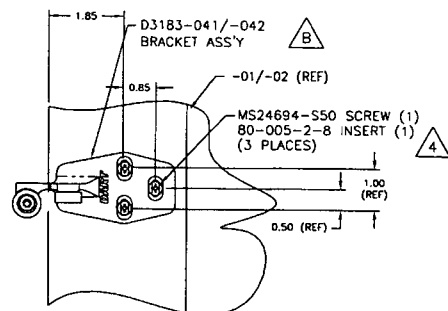
DESIGN		DRAWN BY		DART		DART AEROSPACE LTD.	
CP		RF					
CHECKED		APPROVED		DRAWING NO.		REV. C	
				D412-694		SHEET 5 OF 6	
DATE				TITLE		SCALE	
05.11.23				DOOR ASSEMBLY		NTS	

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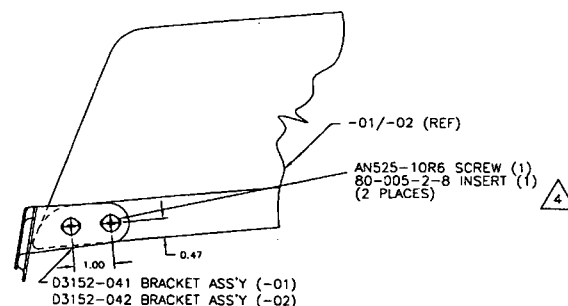
RELEASED
05-12-01

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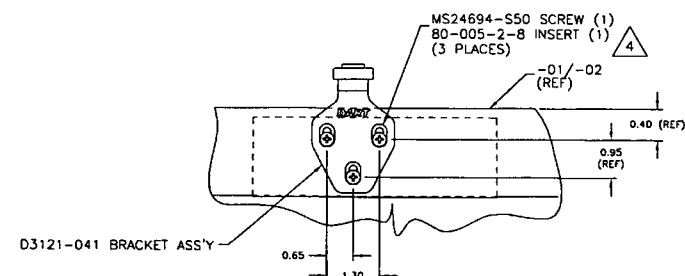
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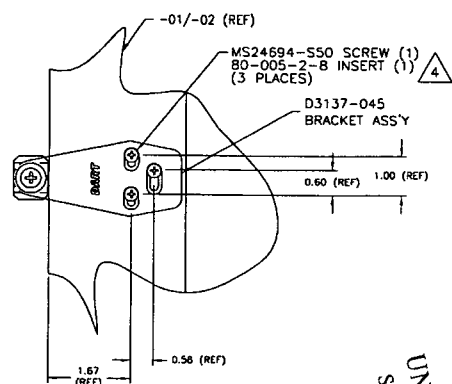
VIEW J



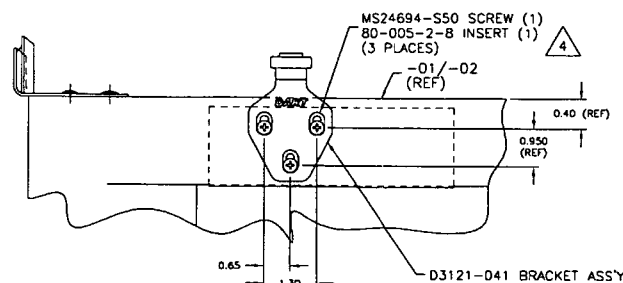
VIEW Q



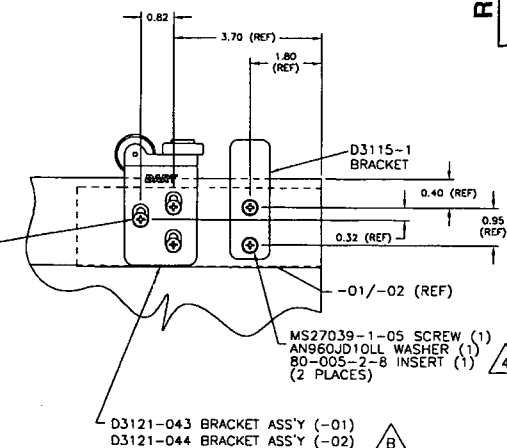
VIEW L



VIEW H



MS24694-S50 SCREW (1)
80-005-2-8 INSERT (1)
(3 PLACES)



VIEW M

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CHECKED #	APPROVED #	DRAWING NO. D412-694	SHEET 6 OF 6
DATE 05.11.23		TITLE DOOR ASSEMBLY	SCALE NTS